Packaging

Page 1

Tuesday, August 27, 2013 1:33:47 PM Item ID: D3183-045 Accept *N900040100* Setup Start Revision ID: Item Name: Bearing Assembly Start Date: 8/27/2013 **Start Qty: 50.00** Cust Item ID: Required Date: 8/30/2013 Req'd Qty: 50.00 Customer: Reference: Run Date: 13-08-25 Process Plan: Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D3183 Rev C1 130 0.00 Small Fab *130* Small Fab 0.00 Memo Small Fab Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183. DAS 27 140 QC5- Inspect part completeness to step on W/O 9-89 *140* 0.00 13. 8 28 QC Memo Quality Control Identify as per dwg & Stock Location: 572 356.00 150 75x 1.W.13-08-28 *150* Packaging

0.00

Memo

WORK ORDER NON-CONFORMANCE / UPDATE OA Closed: Date: Work Order update only Work Order: Part No. Scrap	AEROSPACE
Rework Skid-tube Crosstube Water Jet	
Part No. Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging	
	Engineering Quality Other
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved FAULT CATEGORY	
Landing Gear General	
Bending Bend Folio/Program Outside Dimensions Procedure Not Concentric BOM/Route Grain Over/Under tolerance Set Cracks Broken/Damage/Defect Hardware Part Incorrect Telephone Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Wordshing Contamination Instructions Incomplete/Unclear Part Moved Wordshing Countersink Misaligned/off center Positioned Wrong	ressure/Forced let-up lemperature/Cure Veld Vrong Stock Pulled Other
Wave/Twist in Tube Fit/Function Out of Sequence	

Quality Control

Tuesday, August 27, 2013 1:33:47 PM

105953

Page 2

D3183-045 Item ID: Accept *N900040100* Setup Start Revision ID: Item Name: Bearing Assembly Start Date: 8/27/2013 Start Qty: 50.00 *50* **Cust Item ID:** Required Date: 8/30/2013 Req'd Qty: 50.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: QC: Date: SPC (Y/N): Date: Sequence 1D/ Operation Reject Tool ID Tool # Plan Set Up/ Accept Reject insp. Work Center ID Description Code **Run Hours** Qty Number Stamp Qty 160 QC21- Final Inspection - Work Order Release 0.00 *160* QC 0.00 Memo

113-68-29

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									
QA Closed:		Date:												
Work Orde	ar.				DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Work Order: Part No. NCR No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstub Machining Small Fa noforming Finishin Large Fab Composit	b g	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root		Ī		Desc	ription of work order update		nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	1	iief Eng	Description		Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
						FAI	ULT CAT	regory						
Landir	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualified ions Incomplete/Unclear ined/off center eled d		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence						
. /======														

Picklist Print

Tuesday, August 27, 2013 1:33:45 PM

Work Order ID:

105953

Parent Item:

D3183-045

Parent Item Name: Bearing Assembly

Start Date: 8/27/2013

Required Date: 8/30/2013

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:	IPP A04.02.18No	cw issueKJ/DS											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit		Qty Issued	Date Issued	Status
D3183-9 CAP		Manufactured	No				Each	135.0000		50		SB_	1360/27
				Location		Loc Oty	<u>L.</u>	oc Code		•			
				FG 8	9492	5 5							
				ST235		2							
					6380 8952	1							
				ST235B	05446	128 102							
					8952	1							
D2102 Z				91	9530	25			<u> </u>	5			
D3183-5 Bearing		Manufactured	No			110	Each	84.0000	ا حمد	50	······································	ଷ	13/20/27
				Location		Loc Oty	<u>La</u>	oc Code					
				ST235B		84							
)5622 3653	82 2			_7				

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									
QA Closed:			Date:												
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No						Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro Rec/Sto	Engineering Quality Other			
Root					Desc	l ription of work order update		Initial	Ac	ction	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ct	nief _. Eng	Desc	cription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							EA	III T CAT	TEGORY.						
1				1			FA	ULI CAI	FEGORY						
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea	nk/Ripple	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Grain Hardwa Inspecti Instruct	ion Incomplete/Lions Incomplete/ ions Incomplete/ ined/off center iled	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
		Marks/Ch Turning S Wave/Tw	equence			Drill Holes Finish Fit/Function		4	Calibration						





DESIGN	DRAWN BY	
CHECKED	APPROVED	DRAWIN D31
DATE		TITLE

04.02.17

DART AEROSPACE LTD

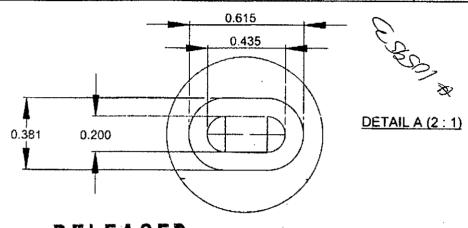
HAWKESBURY, ONTARIO, CANADA NG NO.

83

REV. C SHEET 4 OF 4

BRACKET ASSEMBLY

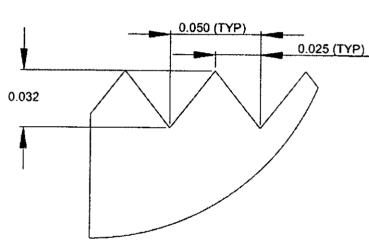
SCALE 1;1

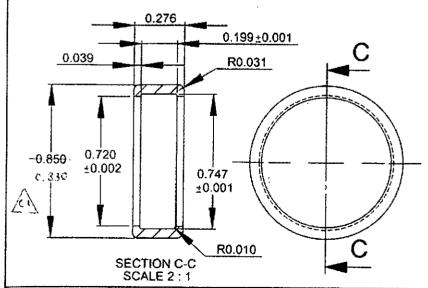


RELEASED

DEO ATTACHED

DETAIL B (20:1)





D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 **UNLESS OTHERWISE NOTED**
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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DQA:		_ Date:													
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only										
QA Closed.		Date.			work Order update only										
Work Orde	er:				DISPOSITION	DISPOSITION AGAINST DEPARTMENT/PROCESS									
				—	Rework	1		Skid-tube Cr	rosstube]	Engineering				
Part N	io.				Scrap		⊢	mall Fab	Pro	Water Jet d. Eng. Coor.	Quality				
					Use-as-is	1	Thern	noforming	Finishing	-	re/Packaging	Other			
NCR N	No	<u>.</u>			Suspected Unapproved]	ļ	Large Fab Co	mposite]	Supplier				
		_	,		<u> </u>	,					, 	-			
Root			_	Desci	ription of work order update	1	Initial	Action		Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descriptio	on	Date	Verification	QC Inspector			
Design	\blacksquare														
Doc/Data												·			
Equip/Tooling															
Handling/Pre		İ													
Material															
Operator															
Offset/Setup Process															
Supplier										1					
Training															
Transport			'												
Unapproved															
	1	<u> </u>	Latin K			FAI	ULT CAT	TEGORY		I					
Landir	ng Gear				General							<u> </u>			
	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced			
	Centre N	ot Conce	ntric		BOM/Route		Grain	_		Over/Under	tolerance	Set-up			
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ot –	Temperature/Cure			
	Crimp/Kink/Ripple/Wave				Burrs		Inspecti	ion Incomplete/Unqual	ified	Part Lost/Missing		Weld			
	Cuffs				Contamination		Instruct	ions Incomplete/Uncle	ar	Part Moved		Wrong Stock Pulled			
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong				
	Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
	Inspection	n Strip in	Tube		Drawing		Misread	d							
,	Marks/C	hatter	•		Drill Holes		Off-set								
	Turning 9	Sequence			Finish		Out of (Calibration							
	Wave/Tv	vist in Tub	10	- 1	Fit/Function		Out of s	Seguence				-			